




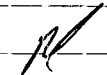




# Work Order ID 64314


Thursday, December 02, 2010 8:57:42 AM

Page 1

Item ID:	D2587	Accept		Setup	Start	
Revision ID:						
Item Name:	Door Slug, 350 Hinge				Stop	
Start Date:	12/2/2010	Start Qty:	30.00		Cust Item ID:	
Required Date:	12/9/2010	Req'd Qty:	30.00		Customer:	
Reference:						


Approvals:	Process Plan:		Date:	10-12-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2587	Rev A1								


100		0.00							
	FLOW WATER JET								
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
6061 .040	1-Cut as per Dwg D2587 <input type="checkbox"/> Dwg Rev: A1 <input type="checkbox"/> Prog Rev: A1 <input type="checkbox"/> 2- Deburr if necessary								

10-12-13

42

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC									
Quality Control	Memo	0.00							

10-12-13

120		0.00							
	QC8- Inspect parts - second check								
QC									
Quality Control	Memo	0.00							

10/12/13

count  
x42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 64314

Thursday, December 02, 2010 8:57:42 AM

Page 2

Item ID:	D2587	Accept		Setup	Start	
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Required Date:	12/9/2010	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00		⇒ 34		x42	0		
140  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							112 BR 10-12-13.
150  Packaging	Identify as per dwg & Stock Location: 017	0.00							
Packaging	Memo	0.00							11/14/14 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries


**Work Order ID 64314**


Thursday, December 02, 2010 8:57:42 AM

Page 3

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Required Date:	12/9/2010	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

10/12/14 

u 10.12.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, December 02, 2010 8:57:46 AM

Page 1

Work Order ID: 64314

Parent Item: D2587

Parent Item Name: Door Slug, 350 . Inge



Start Date: 12/2/2010

Required Date: 12/9/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ D ☐ 04.05.31 ☐ Step 2 changed ☐ KJ/JLM ☐  
IPP ☐ E ☐ 06.07.31 ☐ Waterjet ☐ EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

100

sf

53.9300

0.016

0.505263



10-12-13

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT21

53.93

111224

2

113004

51.93

113004

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





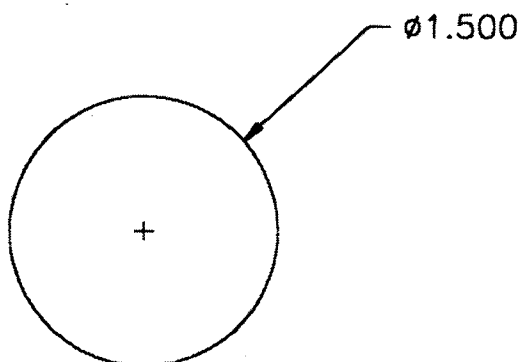
**DART**




DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED	APPROVED	D2587	SHEET 1 OF 1
<i>M. M.</i>	<i>M. M.</i>	TITLE	SCALE
DATE		DOOR SLUG	1:1
96:07:11			
AI <i>Ky</i> 03.09.16		ADD 6061-T6 OPTION	

**RELEASED**  
9607/23 BCU

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *64314*



OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B)   
MATERIAL: 5052-H32, 0.040 THICK  
FINISH: ACID ECTCH, ALODINE